DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027178
Date Inspected: 11-Feb-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1430
Location: Job Site

CWI Name: Salvador Merino and Fred Von Hoff

CWI Present:	☑ Yes	☐ No					
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At OBG 13W-PP118.5-W3, #3 lifting lug hole infill plate to top deck plate outside, ABF welder Mike Jimenez was observed continuing to perform 1G Shielded Metal Arc Welding (SMAW) welding fill pass on the infill plate to top deck plate butt joint. The welder was noted using 3/16” diameter E7018H4R implementing Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU Rev.1 for the Seismic Performance Critical Member (SPCM) butt joint. During welding, ABF QC Salvador Merino was noted monitoring the welder’s welding parameters with measured working current of 280 amperes on the 3/16” diameter E7018H4R electrode. The welder was noted preheating the plates to more than 150°F using propylene gas torch prior welding. During the shift, fill pass welding on the top side location of the butt joint was still continuing when fellow QA Rob De Armond took over the observations on this welding work.

At OBG 13E PP118.5 E4, #4, lifting lug hole infill plate to top deck plate outside, ABF welder Salvador Sandoval was noted fitting up the infill plate to the top deck. The welder was noted using a copper plate as backing to the infill plate to be welded. The infill plate was also noted beveled to 45 degrees and the bevel surface smoothly ground. ABF QC Fred Von Hoff was noted monitoring the fit up work of the infill plate. During the shift, fit up of the infill plate to the top deck plate was still continuing when fellow QA Rob De Armond also took over the observations on this fit up work.

WELDING INSPECTION REPORT

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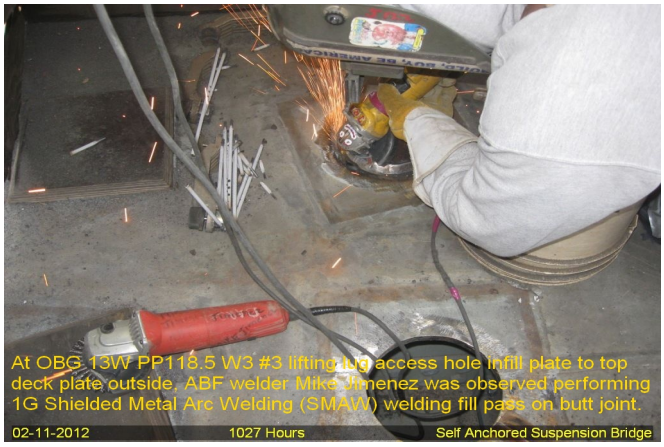
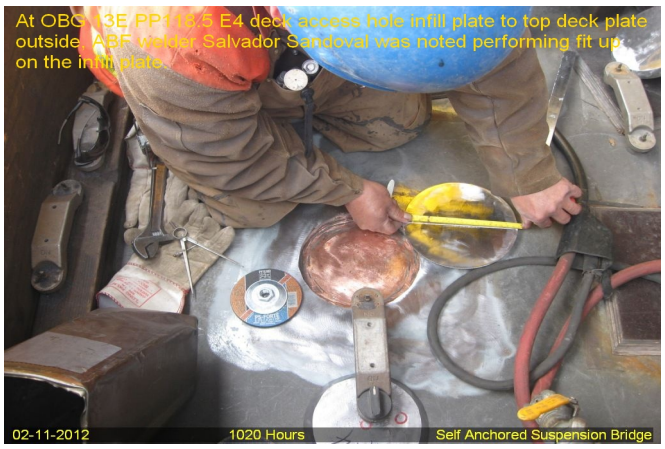
At the Tower Base, ABF personnel were noted grinding the diaphragm plate bevel in preparation for the welding of the 13 meters diaphragm to the tower shafts and shear plates. Other ABF personnel were also noted grinding/cleaning the backing bar to be used during welding. After grinding/cleaning the backing bars, the welder has measured and cut the backing bar to suit the length of the weld joint to be welded. During the shift, grinding of the bevel of 13 meters diaphragm plates and cutting of backing bars were still continuing and should remain tomorrow.





Summary of Conversations:

No significant conversation ocurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo,Joselito	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer